CLAIMS

What is claimed is:

1. A device for deburring the inside of a longitudinally seam-welded pipe, comprising:

a retention arm secured outside a longitudinally seam-welded pipe in an area of the pipe that has not yet been closed, said retention arm having an end zone which is located behind the welding spot;

a frame part arranged in the end zone of the retention arm and constructed for tilting longitudinally in direction of the pipe about a tilt axis by a tilt angle,

an adjustment mechanism, arranged on a leading end of the frame part, for adjusting the tilt angle of the frame part; and

a scraping tool supported by the frame part and bearing against an inside surface of the pipe at a scraping point, for removing burrs and discharge thereof via a chip removal slot in the frame part;

wherein the tilt axis is located, as viewed in an advance direction of the pipe, behind the scraping point at a trailing end of the frame part.

2. The device of claim 1, wherein the end zone of the retention arm is configured as fork having a pair of parallel prongs, with the frame part arranged between the prongs and having opposite longitudinal sides, with each longitudinal sides having a pin extending in the tilt axis, wherein the pin of one longitudinal side is rotatably supported on a top surface of one of the prongs, and the pin of the other one of the longitudinal sides is rotatably supported on a top surface of the other one of the prongs.

3. The device of claim 1, and further comprising a follower roller rotatably supported by the frame part in front of the scraping point, as viewed in advancing direction.

4. The device of claim 3, wherein the follower roller is disposed between the scraping tool and the adjustment means.

5. The device of claim 1, wherein the adjustment means includes a hydraulically controllable adjusting cylinder.

6. The device of claim 1, wherein the adjustment means is constructed to realize an adjustment of the scraping tool by about 0.1 mm .

7. A method for adjusting a device of claim 1 for deburring the inside of a longitudinally seam-welded pipe, comprising the steps of:

adjusting the retention arm and thus the scraping tool mounted on the frame part; and

aligning the adjustment means to a mid-position at an adjustment in a plus and minus range.

8. The method of claim 8, wherein the adjustment of the retention arm includes a positional adjustment in a longitudinal plane, in a transverse plane, and about a longitudinal axis of the retention arm, in dependence on a ratio of wall thickness to diameter of the pipe being welded.

9. The method of claim 8, wherein the aligning step is realized to correct a preset position of the scraping tool in the longitudinal plane.